



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4823-1
Job Sheet 166816



Part No: D4823-1

Job Qty: 12 ea

Part Name: Upper Cutter Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/17/17

Job Tracking No:

Due Date: 11/1/17

Created By: Victoria Michaud-Febrille

Type: Stock

Description:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	12 Ea		10/31/17	0.00	0.00	Start up container	9/2/12/15
100	Bandsaw	12 pcs		10/31/17	0.00	1.01	Bandsaw1	9/2/12/15
110	CNC Vertical Machining	12 pcs		11/1/17	0.30	6.49	HAAS 1	FK 18-01-05
120	QC	12 pcs		11/1/17	0.00	0.00	QC2	FK 18-01-05
130	QC	12 pcs		11/1/17	0.00	0.00	QC8	18/01/06
140	Outsource	12 pcs		11/1/17	0.00	0.00	Outsource4	AT 18/02/07
150	Packaging	12 pcs		11/1/17	0.00	0.00	Packaging2	AT 18/02/07
155	QC	12 pcs		11/1/17	0.00	0.00	QC5	38
180	Packaging	12 pcs		11/1/17	0.00	0.00	Packaging3	188 CML
190	QC21-SA	12 Ea		11/1/17	0.00	0.00	QC21	DAB

Part Op 100 - Cut Blank at 18.300"

Descriptions: 110 - 1-Machine per folio FB223

140 - Issue P/O to ATG : _____ 1- Black Anodize as per Dwg D4823

21
9-00 FEB 08 2008

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T6 5.000X0.375	9	0	0	0

50.375 15.000

Part Specifications

Specifications could not be found.

5017359 X6 5022571

Plex 10/1 / 12:54 PM dart.Michaud-Febrille.Victoria

DART
AEROSPACE
S022572

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Upper Cutter Deflector

PART NO: D4823-1

Revision:

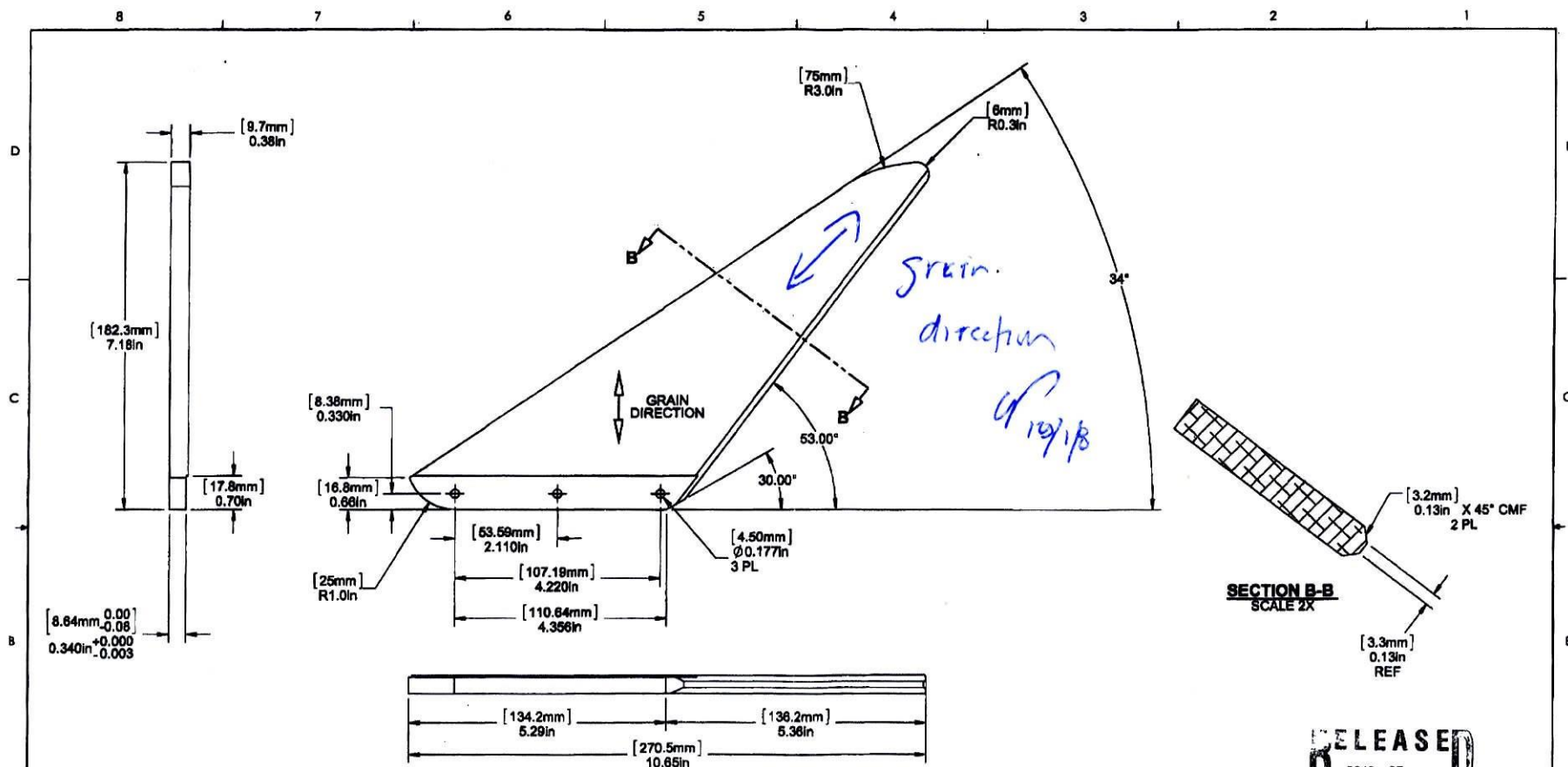
Operation:

Change No:

Start up Operation

Mfg Date: 12/15/17

Job No: 166816



D4823-1 UPPER CUTTER DEFLECTOR

NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T73) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11 (REF DART SPEC M7075T6B)
- 2) FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK,
PRIME IAW MIL-P-2337J TYPE I CLASS N; 1-2 MIL MAX. AS PER QSI 005;
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.01 lbs (0.46 kgs)
- 8) PART DIMENSIONS CONTROLLED BY CAD MODEL FILE: D4823-1-a.IGES (OR D4823-1-a.STEP)

RELEASED
2013-07-12
MP

A NEW RELEASE		DB	13.05.23
REV.	DESCRIPTION	BY	DATE
DESIGN	DB		
DRAWN	DB		
CHECKED	A.P.		
MFG. APPR.	2/		
APPROVED	1/2		
DE APPR.	1/2		
DATE	13.05.23		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4823	REV. A
TITLE UPPER CUTTER DEFLECTOR	SCALE NTS

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**QA Closed: *[Signature]* Date: FEB 12 2018Work Order update only ☐

Work Order: <u>166816</u> Part No. <u>D823-1</u> NCR No. <u>NCR18-6764</u> <i>Attached</i>		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																																																															
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Description Work Order Deviation Current grain direction direction causes mat'l waste				Disposition Acceptable to orient grain direction along long edge.																																																																																																																																			
				Completed By DAS 12 18/1/8 9-89																																																																																																																																			
				Lead hand / Supervisor Approval Verification <i>[Signature]</i> 18/01/08																																																																																																																																			
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038743

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO038743

PO Date: 1/8/18

Due Date: 2/1/18

Purchase Order
Revision:

Revision Date:

Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

JAN 23 2018

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	166820	D4838-1	Upper Cutter Body, LH Issue P/O: _____ ATG, Hard Black Anodize and Prime as per Dwg D4838-1 Rev. A	Firmed	2/1/18	10 pcs	0 pcs	10 pcs	\$11.61/pcs	\$116.10
2	169613	D4703-043	Lock Pin Base Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, As Per Dwg D4703	Firmed	2/1/18	4 pcs	0 pcs	4 pcs	\$4.06/pcs	\$16.24
3	168229	646.3313	Upper Guide Issue P/O to ATG: _____ Hard Anodize Color Black and Prime as per DWG 646.3300	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$14.46/pcs	\$86.76
4	168224	646.3210	Support Issue P/O to ATG: _____ 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$15.71/pcs	\$94.26
5	168265	646.9710	Body Issue P/O to ATG: _____ Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed	2/1/18	12 pcs	0 pcs	12 pcs	\$15.86/pcs	\$190.32
6	165649	646.9811	Upper Deflector Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, PRIME AS PER DWG 646.9800 REV. A	Firmed	2/1/18	16 pcs	0 pcs	16 pcs	\$33.96/pcs	\$543.36
7	169180	649.5010	Deflector Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, AND PRIME AS PER DWG 649.5000 REV. D	Firmed	2/1/18	5 pcs	0 pcs	5 pcs	\$35.36/pcs	\$176.80
8	169184	649.5214	Bracket Issue P/O to ATG: _____ Hard Anodize Color Black and Prime as per Dwg 649.5200	Firmed	2/1/18	5 pcs	0 pcs	5 pcs	\$10.36/pcs	\$51.80
9	169748	650.9201		Firmed	2/1/18	20 pcs	0 pcs	20 pcs	\$7.96/pcs	\$159.20

JAN 24 2018



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038743

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
10	169630	D4842-1	Eyelet Bracket Assembly Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 650.9200	Firmed	2/1/18	8 pcs	0 pcs	8 pcs	\$13.41/pcs	\$107.28
11	169388	647.7819 ✓	Lower Cutter Deflector Outsource process- Issue P/O to ATG : _____ HARD ANODIZE COLOR BLACK, PRIME AS PER DWG D4842	Firmed	2/1/18	10 pcs	0 pcs	10 pcs	\$12.61/pcs	\$126.10
12	168245	646.3715	Cross Bracket Fwd Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 647.7819	Firmed	2/1/18	10 pcs	0 pcs	10 pcs	\$7.61/pcs	\$76.10
13	168267	646.9712	Strut Doubler Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$15.86/pcs	\$95.16
14	168268	646.9713	Body Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.9700	Firmed	2/1/18	5 pcs	0 pcs	5 pcs	\$8.86/pcs	\$44.30
15	169381	647.1610	Body Issue P/O to ATG : _____ Anodize, Color Black, Prime as per Dwg 646.9700	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$12.06/pcs	\$72.36
16	169485	647.7612	Wiper Deflector Fwd Issue P/O to ATG : _____ 1- Hard Anodize, Color Black and Prime as per Dwg, 647.1600	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$12.06/pcs	\$72.36
17	166816	D4823-1	Breakaway Tip Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as Per Dwg 647.7600	Firmed	2/1/18	12 pcs	0 pcs	12 pcs	\$12.51/pcs	\$150.12
Grand Total:									\$2,178.62	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program



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PURCHASE ORDER

PO038743

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
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Special Comments:

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1	166820	D4838-1	Upper Cutter Body, LH Issue P/O: _____ ATG, Hard Black Anodize and Prime as per Dwg D4838-1 Rev. A	Firmed	2/1/18	10 pcs	0 pcs	10 pcs	\$11.61/pcs	\$116.10
2	169613	D4703-043	Lock Pin Base Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, As Per Dwg D4703	Firmed	2/1/18	4 pcs	0 pcs	4 pcs	\$4.06/pcs	\$16.24
3	168229	646.3313	Upper Guide Issue P/O to ATG: _____ Hard Anodize Color Black and Prime as per DWG 646.3300	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$14.46/pcs	\$86.76
4	168224	646.3210	Support Issue P/O to ATG: _____ 1- Hard Anodize Color Black and Prime as per Dwg 646.3200	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$15.71/pcs	\$94.26
5	168265	646.9710	Body Issue P/O to ATG: _____ Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed	2/1/18	12 pcs	0 pcs	12 pcs	\$15.86/pcs	\$190.32
6	165649	646.9811	Upper Deflector Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, PRIME AS PER DWG 646.9800 REV. A	Firmed	2/1/18	16 pcs	0 pcs	16 pcs	\$33.96/pcs	\$543.36
7	169180	649.5010	Deflector Issue P/O to ATG: _____ HARD ANODIZE COLOR BLACK, AND PRIME AS PER DWG 649.5000 REV. D	Firmed	2/1/18	5 pcs	0 pcs	5 pcs	\$35.36/pcs	\$176.80
8	169184	649.5214	Bracket Issue P/O to ATG: _____ Hard Anodize Color Black and Prime as per Dwg 649.5200	Firmed	2/1/18	5 pcs	0 pcs	5 pcs	\$10.36/pcs	\$51.80
9	169748	650.9201		Firmed	2/1/18	20 pcs	0 pcs	20 pcs	\$7.96/pcs	\$159.20

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11	169388	647.7819	Lower Cutter Deflector Outsource process- Issue P/O to ATG : _____ HARD ANODIZE COLOR BLACK, PRIME AS PER DWG D4842	Firmed	2/1/18	10 pcs	0 pcs	10 pcs	\$12.61/pcs	\$126.10
12	168245	646.3715	Cross Bracket Fwd Issue P/O to ATG : _____ HARD ANODIZE COLOR BLACK, AND PRIME AS PER DWG 647.7819	Firmed	2/1/18	10 pcs	0 pcs	10 pcs	\$7.61/pcs	\$76.10
13	168267	646.9712	Strut Doubler Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.3700	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$15.86/pcs	\$95.16
14	168268	646.9713	Body Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as per Dwg 646.9700	Firmed	2/1/18	5 pcs	0 pcs	5 pcs	\$8.86/pcs	\$44.30
15	169381	647.1610	Body Issue P/O to ATG : _____ Anodize, Color Black, Prime as per Dwg 646.9700	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$12.06/pcs	\$72.36
16	169485	647.7612	Wiper Deflector Fwd Issue P/O to ATG : _____ 1- Hard Anodize, Color Black and Prime as per Dwg, 647.1600	Firmed	2/1/18	6 pcs	0 pcs	6 pcs	\$12.06/pcs	\$72.36
17	166816	D4823-1	Breakaway Tip Issue P/O to ATG : _____ Hard Anodize, Color Black and Prime as Per Dwg 647.7600	Firmed	2/1/18	12 pcs	0 pcs	12 pcs	\$12.51/pcs	\$150.12
Grand Total:									\$2,178.62	

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914595

Date: 06-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chantal Lavoie
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
5 ea	Part: 646.9713 Body Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Job: 22360	Rev: D PO: PO038743	Line: 14
6 ea	Part: 647.1610 Wiper Deflector Fwd Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Job: 22361	Rev: A PO: PO038743	Line: 15
6 ea	Part: 647.7612 Breakaway Tip Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - .2 mils) per drawing. Job: 22362	Rev: NC PO: PO038743	Line: 16
12 ea	Part: D4823-1 Upper Cutter Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - .2 mils) per drawing. Job: 22363	Rev: A PO: PO038743	Line: 17
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>6/2/18</u> Certified Signature: <u>J. van Richten</u>			
Made in Canada			



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 914595

Date: 06-Feb-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

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Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via
Quantity	Description	
	Receiver Signature: _____	
	A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited.	
	Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.	
	Made in Canada	



Non-Conformance Report

Reviewed
DQA:
Date:

Printed on: Monday, February 12, 2018

Details			
Raised Date 2/12/2018	Status Open	Owner Williamson, Ryan	Number NCR18-6764
Target Date 3/2/2018	Standard		Severity MAJOR
Process Work Order NCR		Audit	
Raised By Person Downing, Eric M		Raised Against (Department or Supplier) Engineering	Fault Category
Details was found on work order Job number 166816 / Serial number S022572 that D4823-1 was manufactured to the wrong grain direction. The grain direction was approved by Chris Provencal but Dart only hold type certificates design on these parts.			
Keywords		Product	
Document		Root Cause	
Closed By	Closed Date	Resolution	

Root Cause			
Target Date 2/22/2018	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	

Corrective Action			
Target Date 3/2/2018	Owner Downing, Eric M	Closed Date	Closed By
Details			

Actions			
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Number	Owner	Target Date	Completed Date
Details		Response	
1	Downing, Eric M	2/12/2018	
place all nonconforming parts in Quarantine			
2	Downing, Eric M	2/12/2018	
contact Leonardo Helicopters for approval to manufacture parts with deviated grain directions			
5	Downing, Eric M	2/23/2018	
add approvals from Leonardo to work order and include concession to all parts affected			
6	Provencal, Chris	3/2/2018	
provide stress analysis for approval of grain direction change			

Implementing Corrective Action			
Target Date	Owner	Closed Date	Closed By
3/2/2018	Williamson, Ryan		
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	
3	Williamson, Ryan	3/2/2018	
update all drawings for the D169-841 Cable cutter to indicate that Dart does not hold the design approvals for these parts. Concessions must be completed to approve any changes to the parts			
4	Duval, David	3/2/2018	
Add notes to the BOM's & ROUTES of all the D169-841 Cable cutter parts that Dart does not hold design rights for parts. Type Certificate approval only!			

Verification & Review			
Target Date	Owner	Closed Date	Closed By
3/2/2018	Downing, Eric M		
Details			

Actions			
Number	Owner	Target Date	Completed Date
Details		Response	